Work Order ID 59116

Wednesday, May 26, 2010 1:24:22 PM

Item ID: D3537-1 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Wearpad

Start Date: 5/26/2010 **Start Qty:** 30.00 **Cust Item ID:**

Required Date: 6/4/2010 **Req'd Qty:** 30.00 **Customer:**

Reference:

Approvals: **Process Plan:** ____ **Date:** 10-5-26 **Tooling:** ____ **Date:** ____ **Run Start**

QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3537	Rev C								
100	FLOW WATER JET	0.00				MAT NOT PULLED			
Waterjet	**Memo**	0.00				1B 10-5-31			
FLOW CNC Waterjet	1-Cut as per Dwg D3537 □Dwg Rev: C □Prog Rev: C □2-Deburr if necessary								
304 . 063									
110	QC2- Inspect parts off machine FAI/FAIB	0.00				32			
QC	**Memo**	0.00				1B 10-5-31			
Quality Control									
120	QC8- Inspect parts - second check	0.00				comb			
QC	**Memo**	0.00				32			
Quality Control									

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	NC BRAKE **Memo** 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.□2-Identify as D3537-1	0.00 0.00				32			
140 Large Fab Large Fab	Large Fab **Memo** Qty Description Batch□A/R 2059B Hardcoat 11642 □1-Weld as per Dwg D3537 using Jig DT 8210□2-Remove any weld that penetrated through Wearpadif necessary	0.00 0.00							32
150 QC Quality Control	QC10- Inspect visual per QSI004- ground welds **Memo**	0.00 0.00				32			

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NOTE: Date & initial all entries

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00				32			
	Memo	0.00 S.Sloulu							
170 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
	112588.								
	Memo	0.00				32	BR	10-6-16.	
	START TIME: 3:25 ☐OVEN TEMPERATURE: 320 ☐FINISH TIME: 3:55.								
180 QC Quality Control	QC3- Inspect Part Finish	0.00 =) M	10/06/16			32			
	Memo	0.00							

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 Packaging	Identify as per dwg & Stock Location: FP-17	0.00				32	BR	10-6-16	
Packaging	**Memo**	0.00							
200 QC	QC21- Final Inspection - Work Order Release	0.00						10/06/17	
Quality Control	**Memo**	0.00						MF 10-6-17	

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 26, 2010 1:24:27 PM

Work Order ID: 59116

Parent Item: D3537-1

Parent Item Name: Wearpad

Comments: IPP Rev:A New Issue 07-02-14 JLM

Start Date: 5/26/2010 **Required Date:** 6/4/2010

Start Qty: 30.00 **Required Qty:** 30.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	7.7443	0.106	3.347368			

304/316 Sheet .063

B10-5-31

Location	Loc Qty	Loc Code
MAT	7.74427	
111323	0	
114467	7.74427	

32

114467

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W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	59114
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537 **Rev:** C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.250	+/-0.010	4.258	✓			
3.500	+/-0.010	3.499	✓			
1.965	+/-0.010	1.970	✓			
2.795	+/-0.010	2.793	✓			
3.625	+/-0.010	3.623	✓			
0.220 x 0.380	+/-0.010	224 X 386	✓			

Measured by:	B
Date:	10-5-31

Audited by:	S
Date:	10/06/01

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

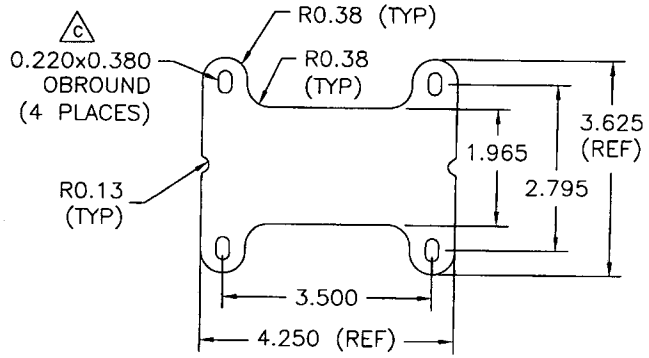
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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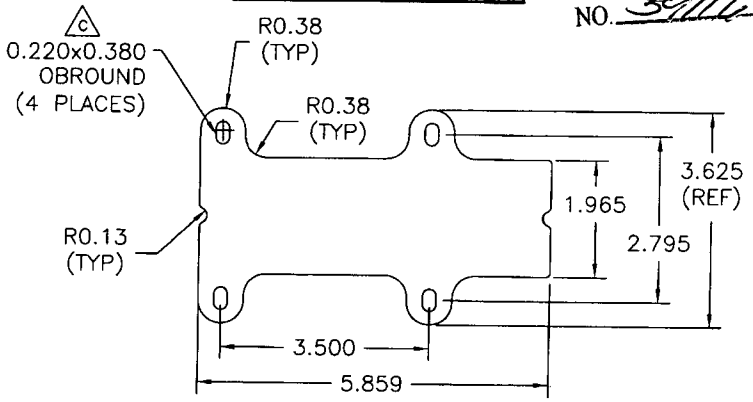
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39111

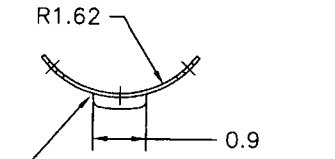
D3537-1F FLAT PATTERN



D3537-3F FLAT PATTERN

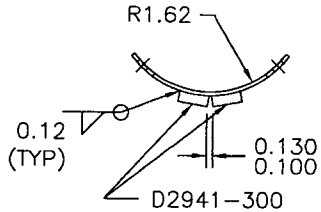


SECTION A-A



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

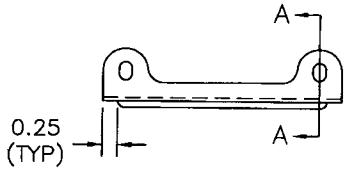
SECTION B-B



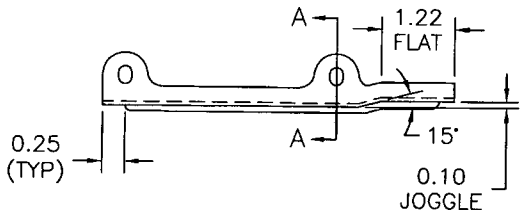
D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

RELEASED
07.05.08 AH
PER ECN 962

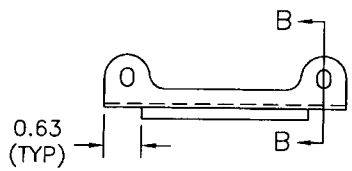
D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)



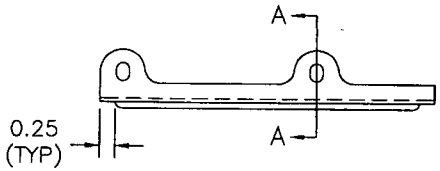
D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
   (REF DART SPEC. M304S16GA)
2) BREAK ALL SHARP CORNERS 0.063 MAX
3) WELD PER QSI 004
4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE

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DESIGN: CB	DRAWN BY: AH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED: [illegible]	APPROVED: [illegible]	DRAWING NO. D3537	REV. C
DATE: 07.04.13		TITLE: WEARPAD	SCALE: 1:2
			SHEET 1 OF 1

Dart Aerospace Ltd

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